

Date: Monday, 6/5/2006 7:34:16 AM  
 User: Kim Johnston

## Process Sheet

|  |                                     |
|--|-------------------------------------|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> : DOOR ASSEMBLY |
| <b>Job Number</b> : 27340A   |                                     |
| <b>Estimate Number</b> : 11454   |                                     |
| <b>P.O. Number</b> : N/A   | <b>Part Number</b> : D41269401      |
| <b>This Issue</b> : 6/5/2006   | <b>Drawing Number</b> : D412-694    |
| <b>S.O. No.</b> : N/A  | <b>Project Number</b> : N/A         |
| <b>Prsht Rev.</b> : NC   | <b>Drawing Revision</b> : C1        |
| <b>First Issue</b> : N/A   | <b>Material</b> : N/A               |
| <b>Type</b> : SMALL /MED FAB   | <b>Due Date</b> : 7/15/2006         |
| <b>Previous Run</b> : 27323A   | <b>Qty:</b> 1 <b>Um:</b> Each       |
| <b>Written By</b> :  |                                     |
| <b>Checked &amp; Approved By</b> : <i>[Signature]</i> 06.06.05                                     |                                     |
| <b>Comment</b> : Est Rev: A 05.12.09 New Issue KJ/RF<br>Est. Rev B New dwg rev. ecn781 06.04.18 EC |                                     |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |    |                  |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|

**Comment:** DOCUMENT CONTROL

Issue red decal labels for D412-694-01 CHG005

|     |                |                    |
|-----|----------------|--------------------|
| 2.0 | COMPOSITE ASSY | COMPOSITE ASSEMBLY |
|-----|----------------|--------------------|

**Comment:** COMPOSITE ASSEMBLY

D412-694-01 Drill Process

- ✓ 1- Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-01 as per Dwg D412-694 page 4 (view P).
- ✓ 2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P).  
 Note: D3151-041 orientation in the door.
- ✓ 3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P).
- ✓ 4- Drill Ø(#30) holes using drill Jig D3144-T1 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T2/-T3 as per Dwg D412-694 page 2.  
 Note: The (12) holes for the (6) nut plates can not be less than 0.290" from inside edge.
- ✓ 5- Open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-041 cover assembly as per Dwg D412-694 page 4 (view P). Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257.
- ✓ 6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-1. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q).

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

- ✓ 7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 3/764" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view H, J).
- ✓ 8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-3LH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø3/764" (0.578) for inserts.
- ✓ 9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-041 bracket. Use unibit to open holes to Ø3/764" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).
- ✓ 10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R/-S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-041 cover.

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*removed. 10/10/25*

*ml 07/10/12*

*ml 07/10/11*

4.0

8000528

Insert



Comment: Qty.: 55.0000 Each(s)/Unit Total : 55.0000 Each(s)  
Insert  
Batch M15893  
A/R Hysol EA934NA M104835  
Expiry Date: 17 May 2008

*✓ ml*  
*ml*

5.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

- 1-Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).
- 2- Sand flush excess Hysol around the insert on both doors.

*ml 07/10/15*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

*10-15 ①*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No:                      PAR #:            Fault Category:                      NCR: Yes No DQA:            Date:           

NOTE: Date & initial all entries

QA: N/C Closed:            Date:

Date: Monday, 6/5/2006 7:34:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

RT 07-10-16

8.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Ex 09/10/16

9.0

D31105

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle

Batch

B27081

✓ ml

10.0

D31151

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket

Batch

D24696

EP

11.0

D31167

Seal ZX2054



Comment: Qty.: 5.6666 f(s)/Unit Total: 5.6666 f(s)

Seal ZX2054

Batch

D27239

EP

12.0

D31169

Seal ZX1267



Comment: Qty.: 6.4166 f(s)/Unit Total: 6.4166 f(s)

Seal ZX1267

Batch

D17463

6.4166 f(s) = 76" 500

EP

PTO

13.0

D3121041

Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Bracket Assembly

Batch

~~B24677~~ B27367

EP

EP 07/09/180

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)                                   |                             |   |                       |                           |                        |                          |
|----------|------|--|-----------------------------|---|-----------------------|---------------------------|------------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A                                     | Corrective Action Section B |   |                       | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|          |      |  | Initial<br>Design Mgr       | Action Description<br>Design Mgr  | Sign &<br>Date        |                           |                        |                          |
| 07/10/15 | 12   | Store did not read FS. They read B.4166 F missing 4 inches of seal | <i>ASUN</i>                 | Scrap seal 6.4166 F. take in box 6.466 F(s) Put note on box do not cut they are already cut at the good length. | <i>my</i><br>07/10/15 | <i>07-10-16</i>           | <i>ASUN</i>            | <i>07-10-16</i>          |
|          |      |  |                             |   |                       |                           |                        |                          |
|          |      |  |                             |   |                       |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: *D* Date: *07/10/15*

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D3121043

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B24678

*CP*



15.0

D31221

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

B25539

*CP*



16.0

D31231

Cam



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cam

Batch

M10536-17

*CP*



17.0

D31241

Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M10536-17

*CP*



18.0

D31242

Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M10536-17

*CP*



19.0

D31261

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

D25492

*CP*



20.0

D31263

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

B28105

*CP*



*CP 7/6/18 @*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



Date: Monday, 6/5/2006 7:34:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D31265

Bracket



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

Batch

B18658-

22.0

D31271

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacer

Batch

B17784-

23.0

D3132041

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

M10536-17-

24.0

D3133042

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

M10536-17-

25.0

D3135041

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch

B19861-

26.0

D3137045

BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET ASSEMBLY

Batch

B27339

27.0

D31381

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

B25178-

CP 507/09/18 @

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D31391

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

B24700

29.0

D31393

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

B24700

30.0

D314005

Door Kit



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Door Kit

Batch

B27340A

ml 07/10/10

31.0

D31411

Spring #204-032-734-001



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring #204-032-734-001

Batch

B34725

ml 07/10/10

32.0

D31443

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B18816

33.0

D314413

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B24723

34.0

D3144109

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B23145

ml 07/09/18 @

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D3144111

Doubler



*CP*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B27380-

36.0

D31481

Clevis



*CP*

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

Batch

M10536-17-

37.0

D3151041

Doubler Assembly



*CP*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler Assembly

Batch

B24685-

38.0

D3152041

Bracket Assembly



*CP*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B18867-

39.0

D3155041

Bracket Assembly



*CP*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

~~B24686~~ / B27178-

40.0

D3155042

Bracket Assembly



*CP*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B26933-

41.0

D31561

Bracket



*CP*

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Batch

B24706 (14) - B24772 (14) -

*7/6/180*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

D3162041

Bracket Assembly



*EP*



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bracket Assembly

Batch

B24688-

43.0

D3162043

BRACKET ASSEMBLY



*EP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B27348-

44.0

D3162044

BRACKET ASSEMBLY



*EP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B24452-

45.0

D3163041

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover Assembly

B27349

*ml*

46.0

D3183041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B21893

*✓ ml*

47.0

D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

B24956A

*✓ ml*

48.0

D33081

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Doubler

Batch

B21912-

*EP*  
*EP 07/09/18 @*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



Date: Monday, 6/5/2006 7:34:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

49.0

AN52510R6

Screw



CP



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

M15943

50.0

AN52510R7

Screw



CP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

Batch

M104214

51.0

AN960JD8

Washer



CP



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M104374

52.0

AN960JD10L

Washer



CP



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch

M103044

53.0

AN960JD10LL

Washer



CP



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Washer

Batch

M19600

54.0

AN960JD416L

Washer



CP



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M105408

55.0

BSP45

Commercial Rivet



CP



Comment: Qty.: 79.0000 Each(s)/Unit Total : 79.0000 Each(s)

Commercial Rivet

Batch

M11821

CP 07/09/180

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

56.0

BSP46

Commercial rivet



EP



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Commercial rivet  
Batch M109098

57.0

M7885243

(CR3213-4-03)

Rivet



EP



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Rivet  
Batch M14477

58.0

MS203922C9

Pin



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pin  
Batch M11784

59.0

MS203922C17

Pin



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pin  
Batch M1735 (X) M18949 (X)

60.0

MS203923C21

Pin



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pin  
Batch M11765

61.0

MS20426AD33

Rivet



EP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Rivet  
Batch M1563

62.0

MS20426AD45

Rivet



EP



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Rivet  
Batch M3459

EP 7/18/00

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

63.0

MS20426AD4

Rivet



PTO

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Batch

M12655

64.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

M104248

65.0

MS21042L08

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch

M104812

66.0

MS21072L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nutplate

Batch

M18728

67.0

MS24665151

Cotter Pin



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cotter Pin

Batch

M14526

68.0

MS24693S271

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M14478

69.0

MS24694C5

Screw





Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M11755

PS 4/10/180

| W/O:     |      | WORK ORDER CHANGES   |    |          |     |   |   |
|----------|------|--|----|----------|-----|---|---|
| DATE     | STEP | PROCEDURE CHANGE   | By | Date     | Qty | Approval<br>Mfg / Design<br>Mgr   | Approval<br>QC Inspector  |
| 07/10/18 | 63   | See <u>CA</u> Change Rivets MS 20426 AD 4-7 For<br>M 7885/3-4 (X12) M104625<br>Put MS 20426 AD 4-7 back in store | ml | 07/10/18 |     | <br>07/10/18 | <br>07-10-23 |
|          |      |  |    |          |     |   |   |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

70.0

MS24694S5

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Screw  
Batch M18949

EP.



71.0

MS24694S50

Screw



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)  
Screw  
Batch M104625

EP.



72.0

MS24694S98

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Screw  
Batch M104156

J

EP.



73.0

MS27039105

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw  
Batch M3501

EP.



74.0

MS27039106

Screw



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)  
Screw  
Batch M11754

EP.



75.0

MS27039108

Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)  
Screw  
Batch M104215

EP.



76.0

MS35275233

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw  
Batch M11822

J

EP.



EP 07/09/180

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



Date: Monday, 6/5/2006 7:34:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

77.0

MS35649264

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

M11822

*CP*

78.0

MS356503252

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

M11735

*CP*

79.0

MS518597

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M11822

*CP*

80.0

NAS43DD310

Spacer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Spacer

Batch

M19347

*CP*

81.0

NAS43DD314

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Batch

M19347

*CP*

*CP 07/09/180*

82.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process

✓ 1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.

Note: Start installation window side. Wait to fix D3162-041/-043.

✓ 2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

✓ 3- Connect D3132-041 Rod Weldment with D3122-1 Lever and D3133-041 Rod Weldment as per Dwg D412-694 page 4 (view P).

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

✓ 5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

✓ 6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and page 2. Adjust rod weldment until everything works properly and looks in place.

*ml 07/10/16*

83.0

QC5

INSPECT WORK TO CURRENT STEP



*17-10-18*



Comment: INSPECT WORK TO CURRENT STEP

84.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process (Continued)

1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

2- Install D3110-5 Handle Assembly in the D3163-041 Cover Assembly. Ensure Handle works freely. Ensure D3163-041 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes around the handle. Install the bracket with the holes from the small square of the cover (Ø0.250")

4- Open 15/64" (0.234) holes to D3163-041 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-3 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

7- Install D3126 Brackets and D3138-1 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN).

8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

*ml 07/10/18*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

(PTO)

85.0

QC5

INSPECT WORK TO CURRENT STEP



07-10-23 ①

Install on Air Craft.

Comment: INSPECT WORK TO CURRENT STEP

86.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

- 1- Finish installing D3163-041 in the door.
- 2- Install red decal before closing cover.

ml 07/10/23 ①

87.0

QC5

INSPECT WORK TO CURRENT STEP



07-10-23 ①

Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

88.0

PACKAGING 1

- PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: —

CY 07/10/24 ①

89.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07/10/25

Job Completion



| W/O:    |              | WORK ORDER CHANGES                    |    |      |     |                                 |                          |
|---------|--------------|---------------------------------------|----|------|-----|---------------------------------|--------------------------|
| DATE    | STEP         | PROCEDURE CHANGE                      | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
| A-10-23 | 85.0<br>87.0 | SWAP Step 87.0 for 85.0. Perm. Change |    |      |     | A-10-23                         | A-10-23                  |
|         |              |                                       |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| Qty | Q1 | Q2 | Q3 | Q4 | Part Number   | Description               |
|-----|----|----|----|----|---------------|---------------------------|
| X   |    |    |    |    | D412-694-01   | DOOR ASSEMBLY             |
|     | X  |    |    |    | D412-694-02   | DOOR ASSEMBLY             |
|     |    | X  |    |    | D412-694-03   | DOOR ASSEMBLY             |
|     |    |    | X  |    | D412-694-04   | DOOR ASSEMBLY             |
|     |    |    |    | 1  | D8110-1       | ESCU TO HON               |
|     |    |    | 1  | 1  | D8110-3       | HANDLE                    |
| 1   | 1  |    |    |    | D8110-5       | HANDLE ASSEMBLY           |
|     |    | 1  | 1  |    | D8111-041     | PLATE ASSEMBLY            |
|     |    | 2  | 2  |    | D8112-1       | GUIDE                     |
|     |    | 1  | 1  |    | D8113-1       | SPRING                    |
|     |    | 1  | 1  |    | D8114-1       | PIVOT                     |
| 1   | 1  |    |    |    | D8115-1       | BRACKET                   |
|     |    | 1  | 1  |    | D8116-11-0180 | SEAL                      |
|     |    | 1  | 1  |    | D8116-6-0380  | SEAL                      |
| 1   | 1  |    |    |    | D8116-7-0380  | SEAL                      |
| 1   | 1  |    |    |    | D8116-9-0770  | SEAL                      |
|     |    | 1  |    |    | D8119-041     | COVER ASSEMBLY            |
|     |    | 1  |    |    | D8119-042     | COVER ASSEMBLY            |
|     |    | 1  |    |    | D8120-1       | COVER                     |
|     |    | 1  |    |    | D8120-2       | COVER                     |
|     |    | 1  |    |    | D8120-3       | COVER                     |
|     |    | 1  |    |    | D8120-4       | COVER                     |
| 3   | 3  |    |    |    | D8121-041     | BRACKET ASSEMBLY (ROLLER) |
| 1   |    |    |    |    | D8121-043     | BRACKET ASSEMBLY (ROLLER) |
| 1   | 1  |    |    |    | D8121-044     | BRACKET ASSEMBLY (ROLLER) |
| 1   | 1  |    |    |    | D8122-1       | LEVER                     |
| 2   | 2  |    |    |    | D8123-1       | CAM                       |
| 1   | 1  |    |    |    | D8124-1       | HOOK                      |
| 1   | 1  |    |    |    | D8124-2       | HOOK                      |
|     |    | 1  | 1  |    | D8125-1       | LEVER                     |
|     |    | 1  | 1  |    | D8125-3       | LEVER                     |
|     |    | 1  | 1  |    | D8125-5       | LEVER                     |
|     |    | 1  | 1  |    | D8125-7       | LEVER                     |
| 1   | 1  |    |    |    | D8126-1       | BRACKET (SLIDER)          |
| 1   | 1  |    |    |    | D8126-3       | BRACKET (SLIDER)          |
| 5   | 5  |    |    |    | D8126-6       | BRACKET (SLIDER)          |
| 1   | 1  |    |    |    | D8127-1       | SPACER                    |
|     |    | 1  | 1  |    | D8128-1       | SHIM                      |
|     |    | 2  | 2  |    | D8129-1       | LEVER                     |
|     |    | 2  | 2  |    | D8130-1       | CLEVIS BASE               |
|     |    | 1  | 1  |    | D8131-1       | STOP                      |
| 1   |    |    |    |    | D8132-041     | RCD WELDMENT              |
|     | 1  |    |    |    | D8132-042     | RCD WELDMENT              |
|     | 1  |    |    |    | D8133-041     | RCD WELDMENT              |
| 1   |    |    |    |    | D8133-042     | RCD WELDMENT              |
|     |    | 1  | 1  |    | D8134-1       | RCD                       |
|     |    | 1  | 1  |    | D8134-3       | RCD                       |
| 1   | 1  |    |    |    | D8135-041     | HANDLE WELDMENT           |
| 1   | 1  |    |    |    | D8137-045     | BRACKET ASSEMBLY          |
| 1   |    |    |    |    | D8138-1       | COVER                     |
| 1   | 1  |    |    |    | D8138-2       | COVER                     |
| 1   | 1  |    |    |    | D8139-1       | GUARD                     |
| 1   | 1  |    |    |    | D8139-3       | GUARD                     |
| 1   | 1  |    |    |    | D8139-4       | GUARD                     |
| 1   |    |    |    |    | D8140-05      | DOOR                      |
| 1   | 1  |    |    |    | D8140-06      | DOOR                      |
|     |    | 1  |    |    | D8140-07      | DOOR                      |
| 2   | 2  |    |    |    | D8140-08      | DOOR                      |
|     |    | 1  | 1  |    | D8141-1       | SPRING                    |
|     |    | 3  | 3  |    | D8143-1       | CLEVIS                    |
|     |    | 1  |    |    | D8144-1       | DOUBLER                   |
| 1   |    |    |    |    | D8144-3       | DOUBLER                   |
|     |    | 1  |    |    | D8144-105     | DOUBLER                   |
|     |    | 1  |    |    | D8144-107     | DOUBLER                   |
| 1   |    |    |    |    | D8144-108     | DOUBLER                   |

| Qty | Q1 | Q2 | Q3 | Q4 | Part Number  | Description               |
|-----|----|----|----|----|--------------|---------------------------|
| 1   | 1  |    |    |    | D8144-111    | DOUBLER                   |
|     | 1  |    |    |    | D8144-115    | DOUBLER                   |
|     |    | 1  |    |    | D8144-117    | DOUBLER                   |
|     |    | 1  |    |    | D8144-121    | DOUBLER                   |
|     |    | 1  |    |    | D8144-119    | DOUBLER                   |
|     | 1  |    |    |    | D8144-123    | DOUBLER                   |
| 1   | 1  |    |    |    | D8144-13     | DOUBLER                   |
|     |    | 1  |    |    | D8145-1      | HINGE BRACKET             |
|     |    | 1  |    |    | D8145-2      | HINGE BRACKET             |
|     |    | 1  |    |    | D8145-3      | HINGE BRACKET             |
|     |    | 2  | 2  |    | D8147-1      | FIN                       |
| 2   | 2  |    |    |    | D8148-1      | CLEVIS                    |
|     |    | 2  | 2  |    | D8149-1      | STIRNER PLATE             |
|     |    | 2  | 2  |    | D8150-1      | GUIDE                     |
| 1   | 1  |    |    |    | D8151-041    | DOUBLER ASSEMBLY          |
| 1   |    |    |    |    | D8152-041    | BRACKET ASSEMBLY          |
|     | 1  |    |    |    | D8152-042    | BRACKET ASSEMBLY          |
|     |    | 1  | 1  |    | D8154-1      | KEY                       |
| 1   | 1  |    |    |    | D8155-041    | BRACKET ASSEMBLY          |
| 1   | 1  |    |    |    | D8156-042    | BRACKET ASSEMBLY          |
| 2   | 2  |    |    |    | D8156-1      | BRACKET                   |
|     |    | 2  | 2  |    | D8157-1      | SPACER                    |
|     |    | 3  | 3  |    | D8159-041    | BRACKET ASSEMBLY          |
|     |    | 1  |    |    | D8159-043    | BRACKET ASSEMBLY          |
|     |    | 1  |    |    | D8159-044    | BRACKET ASSEMBLY          |
| 10  | 10 |    |    |    | D8162-041    | BRACKET ASSEMBLY          |
| 1   |    | 1  |    |    | D8162-043    | BRACKET ASSEMBLY          |
| 1   |    | 1  |    |    | D8162-044    | BRACKET ASSEMBLY          |
| 1   |    |    |    |    | D8163-041    | COVER ASSEMBLY            |
| 1   |    |    |    |    | D8163-042    | COVER ASSEMBLY            |
| 1   |    |    |    |    | D8183-041    | BRACKET ASSEMBLY (ROLLER) |
| 1   |    |    |    |    | D8183-042    | BRACKET ASSEMBLY (ROLLER) |
| 1   | 1  |    |    |    | D8203-1      | HANDLE ASSEMBLY           |
| 2   | 2  |    |    |    | D8308-1      | DOUBLER                   |
| 55  | 55 | 21 | 21 |    | 80-005-28    | INSERT (OR SL2002-3-4)    |
| 10  | 10 |    |    |    | AN625-10F6   | SCREW                     |
| 8   | 8  | 4  | 4  |    | AN625-10F7   | SCREW                     |
|     |    | 8  | 8  |    | AN690D10     | WASHER                    |
| 18  | 18 | 4  | 4  |    | AN690D10L    | WASHER                    |
| 13  | 13 | 32 | 32 |    | AN690D10L3   | WASHER                    |
| 6   | 6  |    |    |    | AN690D14H    | WASHER                    |
|     |    | 4  | 4  |    | AN690D16L    | WASHER                    |
| 6   | 6  |    |    |    | AN690D18L    | WASHER                    |
|     |    | 2  | 2  |    | AN690D18L    | WASHER                    |
|     |    | 2  | 2  |    | AN690D18L    | WASHER                    |
|     |    | 10 | 10 |    | ASL4632-80   | INSERT                    |
| 87  | 87 | 50 | 50 |    | 8SP45        | RIVET                     |
|     |    | 12 | 12 |    | PV10-032     | WASHER                    |
|     |    | 6  | 6  |    | PV14-032     | WASHER                    |
| 12  | 12 |    |    |    | M7885/24     | RIVET (OR CR3213-4-3)     |
|     |    | 3  | 3  |    | M7885/34     | RIVET (OR CR3212-4-3)     |
|     |    | 2  | 2  |    | MS20392-1C11 | FIN                       |
|     |    | 7  | 7  |    | MS20392-2C15 | FIN                       |
| 2   | 2  |    |    |    | MS20392-2C17 | FIN                       |
| 2   | 2  | 2  | 2  |    | MS20392-2C9  | FIN                       |
| 2   | 2  |    |    |    | MS20392-3C21 | FIN                       |
| 8   | 8  |    |    |    | MS20426AD3   | RIVET                     |
| 12  | 12 |    |    |    | M7885/34     | RIVET                     |
| 8   | 8  |    |    |    | MS20426AD4   | RIVET                     |

| Qty | Q1 | Q2 | Q3 | Q4 | Part Number  | Description |
|-----|----|----|----|----|--------------|-------------|
| 20  | 20 |    |    |    | MS20426AD4   | RIVET       |
|     |    | 6  | 6  |    | MS21042L06   | NUT         |
| 6   | 6  | 2  | 2  |    | MS21042L08   | NUT         |
|     |    | 5  | 5  |    | MS21042L3    | NUT         |
| 4   | 4  |    |    |    | MS21042L4    | NUT         |
| 4   | 4  |    |    |    | MS21072L3    | NUT/PLATE   |
| 6   | 6  | 9  | 9  |    | MS24695-151  | COTTER PIN  |
| 4   | 4  |    |    |    | MS24695-S271 | SCREW       |
|     |    | 2  | 2  |    | MS24694-C4   | SCREW       |
| 4   | 4  |    |    |    | MS24694-C5   | SCREW       |
| 6   | 6  |    |    |    | MS24694-S5   | SCREW       |
| 18  | 18 |    |    |    | MS24694-S50  | SCREW       |
|     |    | 4  | 4  |    | MS24694-S55  | SCREW       |
|     |    | 2  | 2  |    | MS24694-S53  | SCREW       |
|     |    | 4  | 4  |    | MS24694-S50  | SCREW       |
| 4   | 4  |    |    |    | MS24694-S58  | SCREW       |
|     |    | 2  | 2  |    | MS25281-F6   | CLAMP       |
| 2   | 2  | 2  | 2  |    | MS27039-1-05 | SCREW       |
| 14  | 14 | 12 | 12 |    | MS27039-1-06 | SCREW       |
| 13  | 13 | 6  | 6  |    | MS27039-1-08 | SCREW       |
|     |    | 2  | 2  |    | MS35205-231  | SCREW       |
| 2   | 2  |    |    |    | MS35275-233  | SCREW       |
| 2   | 2  |    |    |    | MS35949-254  | NUT         |
|     |    | 4  | 4  |    | MS35950-305T | NUT         |
| 2   | 2  |    |    |    | MS35950-3252 | NUT         |
| 2   | 2  | 3  | 3  |    | MS31859-7    | WASHER      |
|     |    | 4  | 4  |    | NAS1169-10L  | WASHER      |
|     |    | 14 | 14 |    | NAS388-6-8P  | SCREW       |
|     |    | 15 | 15 |    | NAS39183P    | WASHER      |
| 7   | 7  |    |    |    | NAS39303-10  | SPACER      |
| 6   | 6  |    |    |    | NAS39303-14  | SPACER      |
|     |    | 2  | 2  |    | NAS39303-40  | SPACER      |

#### GENERAL NOTES:

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D8124-1/2 HOOK RESTS AGAINST OUTCUT SHOWN IN VIEW.
- IF REQUIRED, NOTCH D8125-1 LEVER (REF) TO CLEAR THE D8130-1 CLEVIS BASE (REF, 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JIGS, 830-23000-01; D8144-T14-T2-T3; D8183-3; D8162-041-T1 (FOR -01 DOOR ASSY); 830-23000-02; D8144-T14-T8-T9; D8183-4; D8162-041-T2 (FOR -02 DOOR ASSY); D8144-T14-T5-T8; D8119-041-T1; D8112-T14-T2 (FOR -03 DOOR ASSY); D8144-T14-T1-T12; D8119-042-T1; D8112-T14-T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER DART QS 005. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER DART QS 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D412-694-01-02-03-04 DOOR ASSEMBLIES USING D2728-1 DECALS.

|         |          |  |
|---------|----------|--|
| CI      | 06.03.28 | ADD OPTION M7885/3-4   |
| C       | 05.11.23 | ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES |
| B       | 04.10.07 | UPDATE DRAWING   |
| A       | C2.05.21 | NEW ISSUE  |
| DESIGN  | CP       | DRAWN BY RF  |
| CHECKED | #        | APPROVED #   |
| DATE    | 05.11.23 | DRAWING NO. D412-694   |
|         |          | TITLE DOOR ASSEMBLY  |
|         |          | REV. C SHEET 1 OF 6  |
|         |          | SCALE NTS  |

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

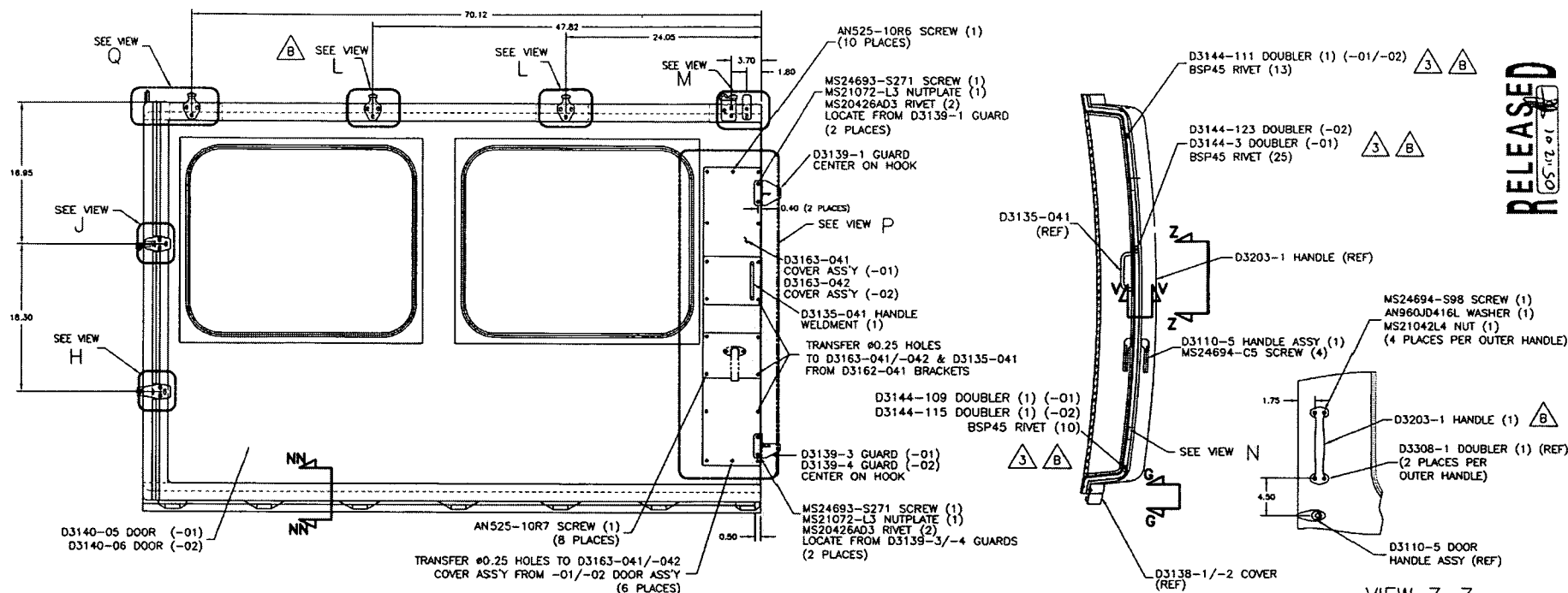
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART** DART AEROSPACE LTD.  
WIMBORNE, DORSET, ENGLAND

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27340A  
ENGINEERING  
RETURN TO  
SHIPPING

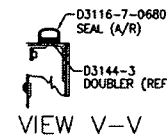
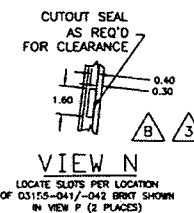
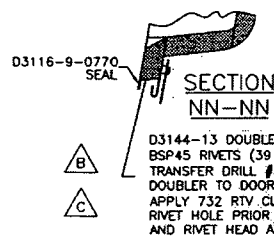
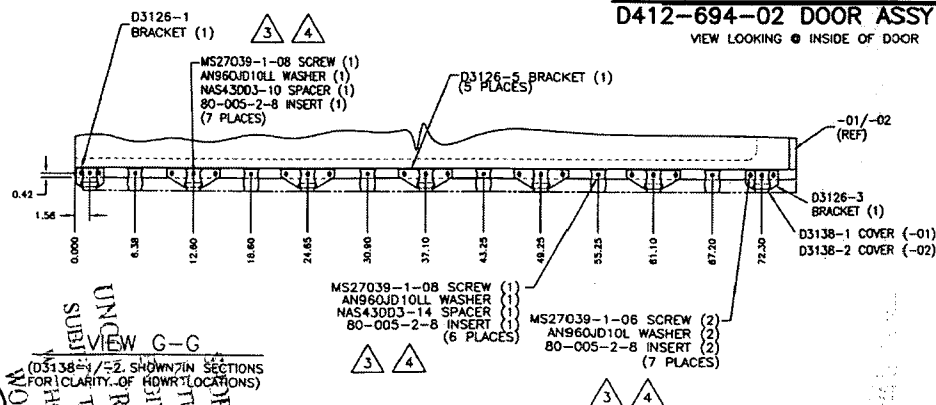
RELEASED  
05.12.01

RELEASED  
05-12-01



**D412-694-01 DOOR ASSY (SHOWN)**  
**D412-694-02 DOOR ASSY (OPP.)**

VIEW LOOKING @ INSIDE OF DOOR



COPYRIGHT © 2002 BY DART AEROSPACE LTD.

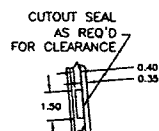
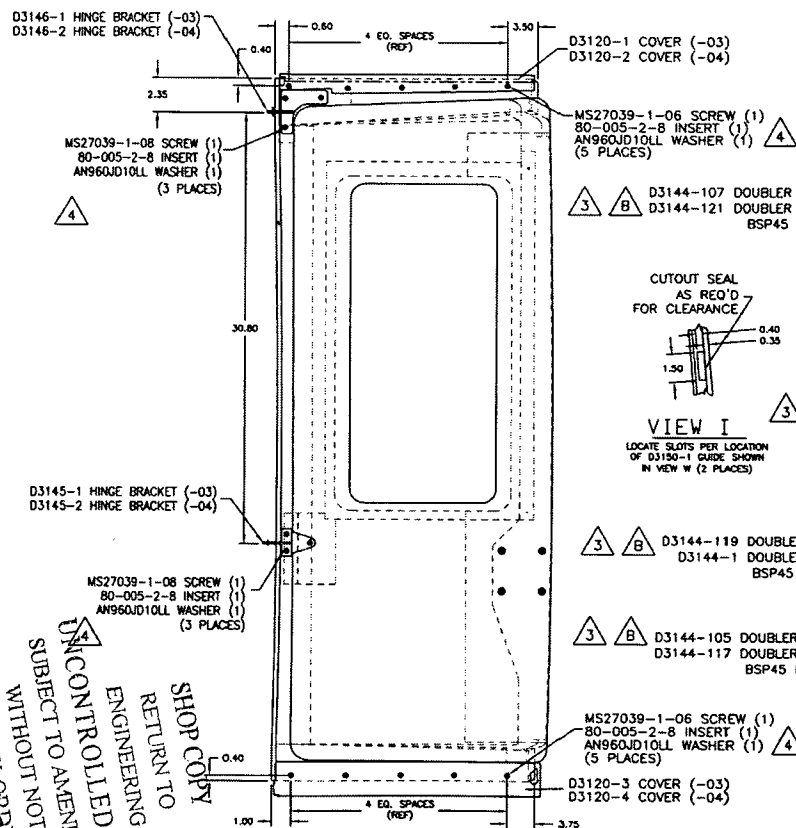
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

|         |                    |          |                    |             |   |
|---------|--------------------|----------|--------------------|-------------|---|
| DESIGN  | CP                 | DRAWN BY | RF                 | <b>DART</b> | DART AEROSPACE LTD.<br>WINDSOR, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | DRAWING NO. | D412-694  |
| DATE    | 05.11.23           | TITLE    | DOOR ASSEMBLY      | REV. C      | SHEET 2 OF 6                                    |
|         |                    |          |                    | SCALE       | NTS   |

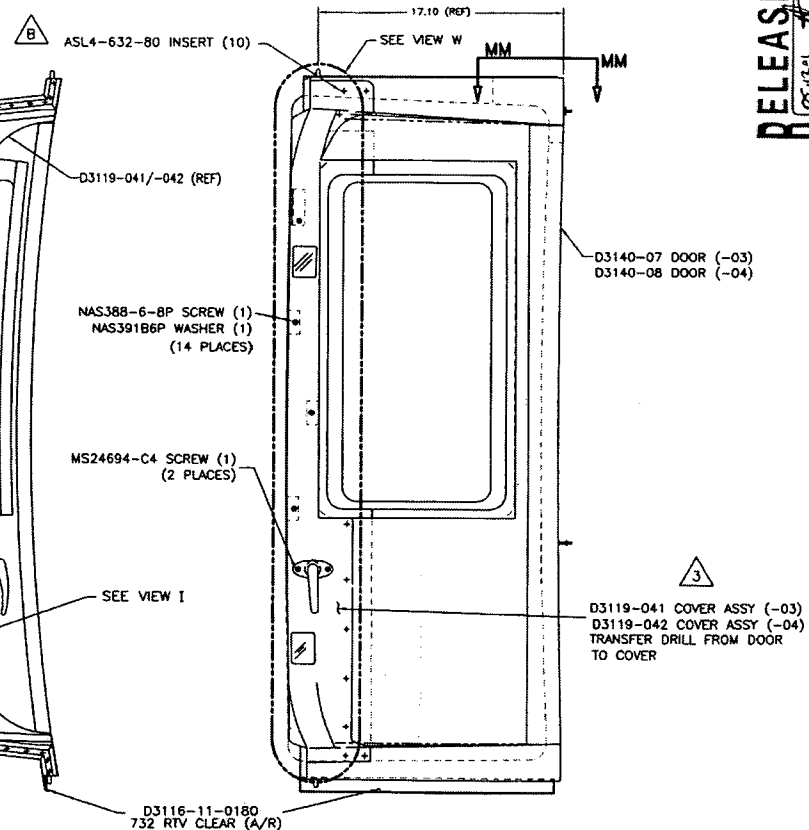
NO. 27340 A  
WORK ORDER  
SUBMIT WITHOUT NOTICE  
UNLESS SHOWN IN SECTIONS  
FOR CLARITY OF HOW LOCATIONS  
TURN TO  
ENGINEERING  
ROLLED COPY  
TO AMENDMENT



RELEASED  
05-12-01

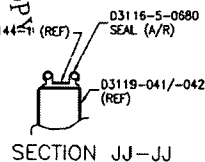


VIEW I  
LOCATE SLOTS PER LOCATION  
OF D3150-1 GUIDE SHOWN  
IN VIEW W (2 PLACES)



D412-694-03 DOOR ASSY (SHOWN)  
D412-694-04 DOOR ASSY (OPP)

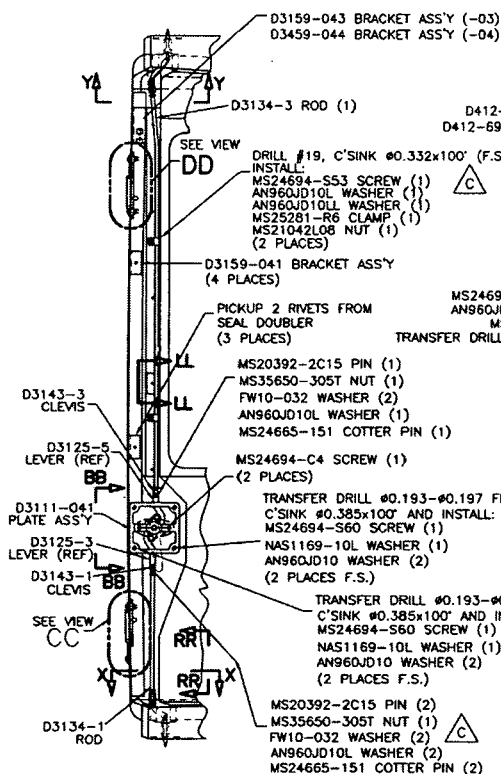
NO. 29340 A  
WORK ORDER  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
NO. 29340 A



SECTION JJ-JJ

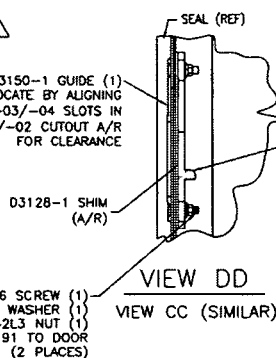
|  |  |                        |                |                         |   |
|--|--|------------------------|----------------|-------------------------|---|
| COPYRIGHT © 2002 BY DART AEROSPACE LTD.  |  | DESIGN<br>CP           | DRAWN BY<br>RF | <b>DART</b>             | DART AEROSPACE LTD.<br>MISSISSAUGA, ONTARIO, CANADA |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |  | CHECKED<br>H           | APPROVED<br>H  | DRAWING NO.<br>D412-694 | REV. C<br>SHEET 3 OF 6                              |
| DATE<br>05.11.23   |  | TITLE<br>DOOR ASSEMBLY |                | SCALE<br>NTS            |   |



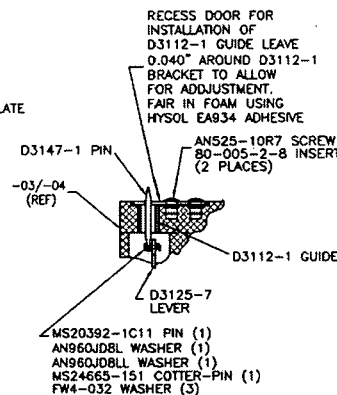


VIEW DD

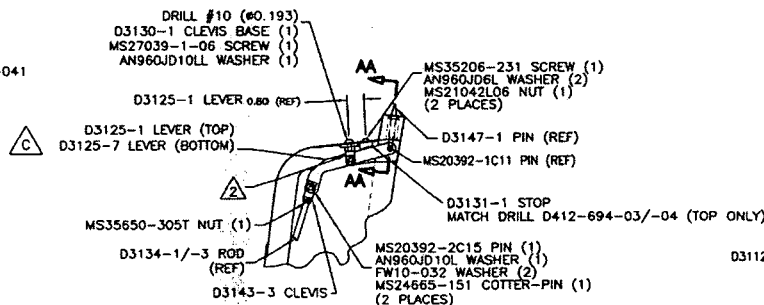
D3119-041/-042 COVER ASS'Y NOT SHOWN FOR CLARITY  
SEAL ALSO NOT SHOWN FOR CLARITY



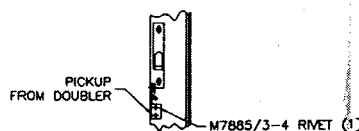
VIEW CC (SIMILAR)



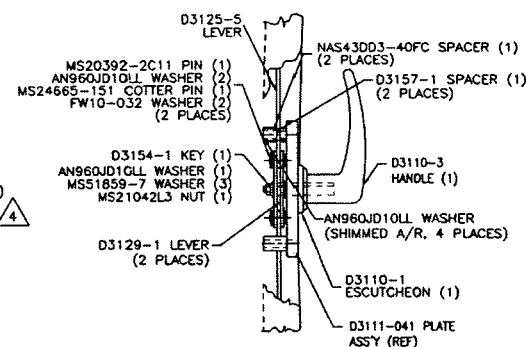
SECTION AA-AA



SECTION FF-FF

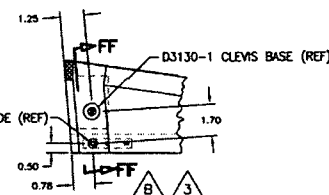


VIEW RR-RR



SECTION BB-BB

VIEW SHOWN WITH MECHANISM IN THE UNLOCKED POSITION FOR CLARITY



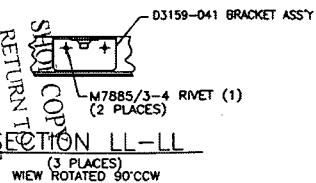
SECTION X-X (SHOWN)

SECTION Y-Y (SIMILAR)

D3125-1 LEVER NOT SHOWN FOR CLARITY

RELEASED

NO. 273470A  
WORK ORDER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

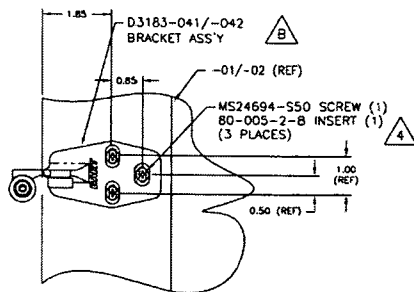


SECTION LL-LL

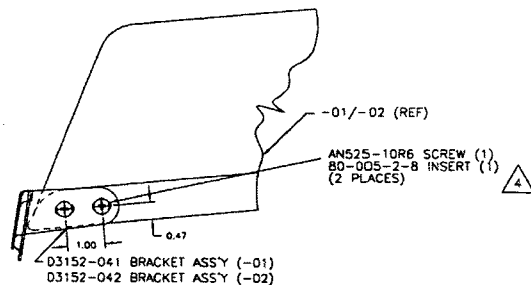
VIEW ROTATED 90°CCW

|   |          |             |               |             |   |
|---|----------|-------------|---------------|-------------|---|
| COPYRIGHT © 2002 BY DART AEROSPACE LTD. |          | DESIGN      | DRAWN BY      | <b>DART</b> | DART AEROSPACE LTD.<br>WARRICKBURT, ONTARIO, CANADA |
| CP                                      | RF       | CHECKED     | APPROVED      |             |   |
| DATE                                    | 05.11.23 | DRAWING NO. | D412-694      | REV. C      | SHEET 5 OF 6  |
|   |          | TITLE       | DOOR ASSEMBLY | SCALE       | NTS   |

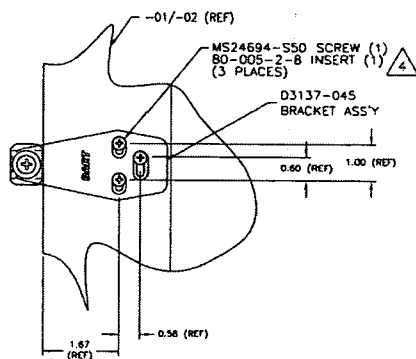
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



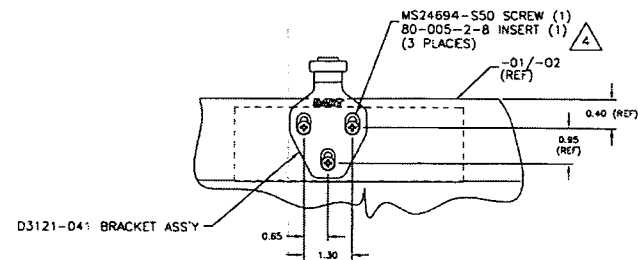
VIEW J



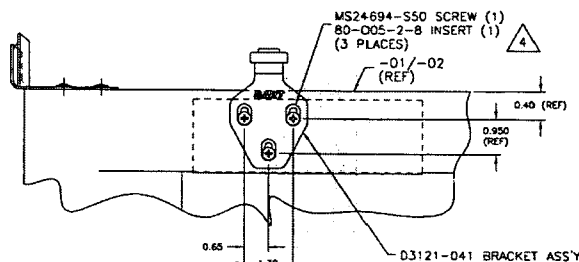
VIEW Q



VIEW H

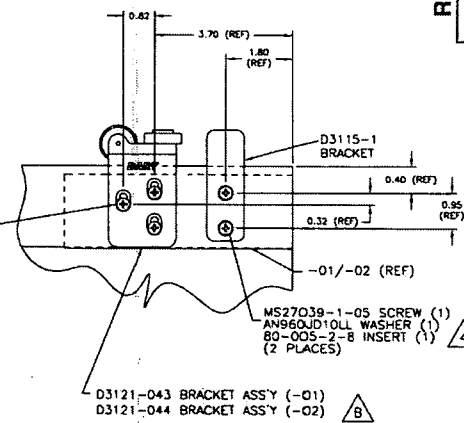


VIEW L



VIEW Q



MS24694-S50 SCREW (1)  
80-005-2-B INSERT (1)  
(3 PLACES)



VIEW M

RELEASED

05-12-01

|   |  |         |   |               |   |             |   |          |        |              |
|---|--|---------|---|---------------|---|-------------|---|----------|--------|--------------|
| COPYRIGHT © 2002 BY DART AEROSPACE LTD.   |  | DESIGN  | CP  | DRAWN BY      | RF  | <b>DART</b> | DART AEROSPACE LTD.<br>HAMPSHIRE, ONTARIO, CANADA |          |        |              |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |  | CHECKED |  | APPROVED      |  |             |   |          |        |              |
|   |  | DATE    |   | 05.11.23      |   | DRAWING NO. |   | D412-694 | REV. C | SHEET 6 OF 6 |
|   |  | TITLE   |   | DOOR ASSEMBLY |   |             |   | SCALE    |        |              |
|   |  |         |   |               |   |             |   |          |        |              |
|   |  |         |   |               |   |             |   |          |        |              |

NO. 27340A  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY